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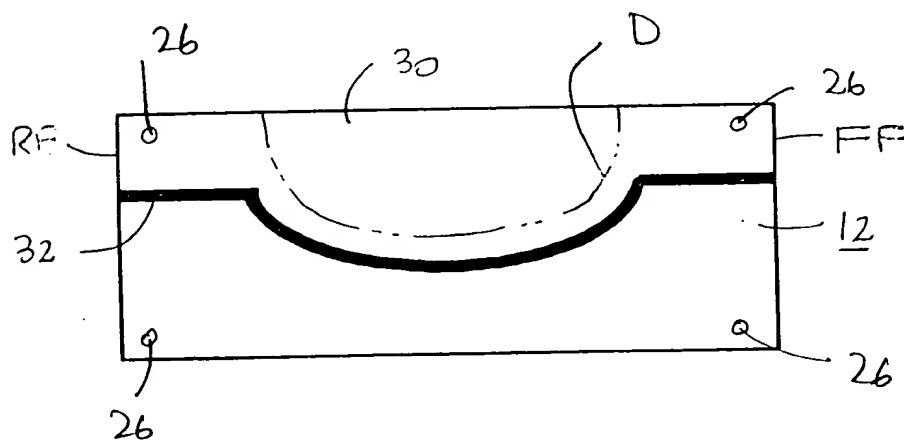
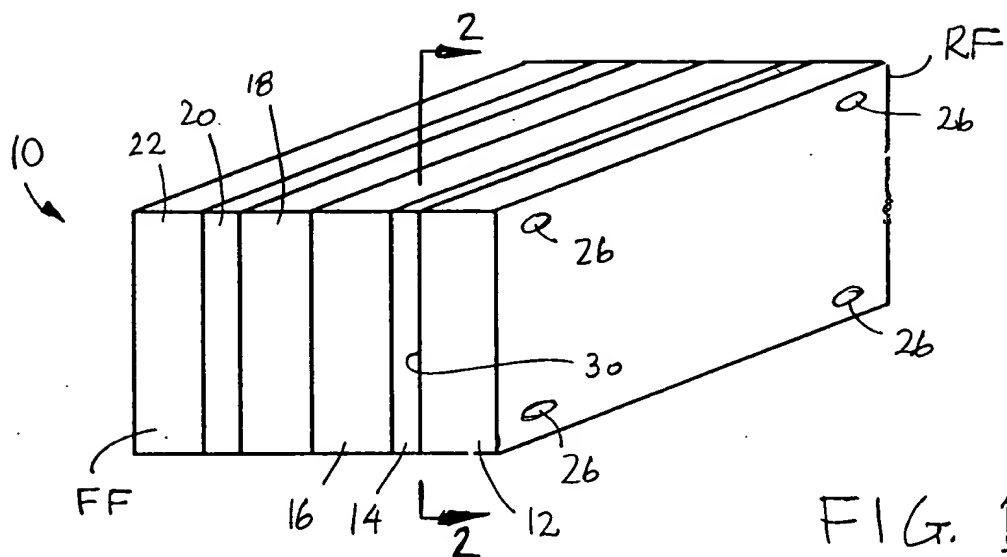
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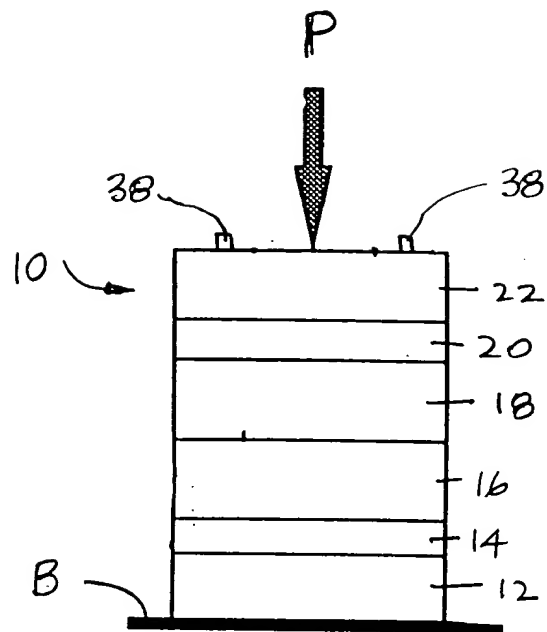


FIG. 3

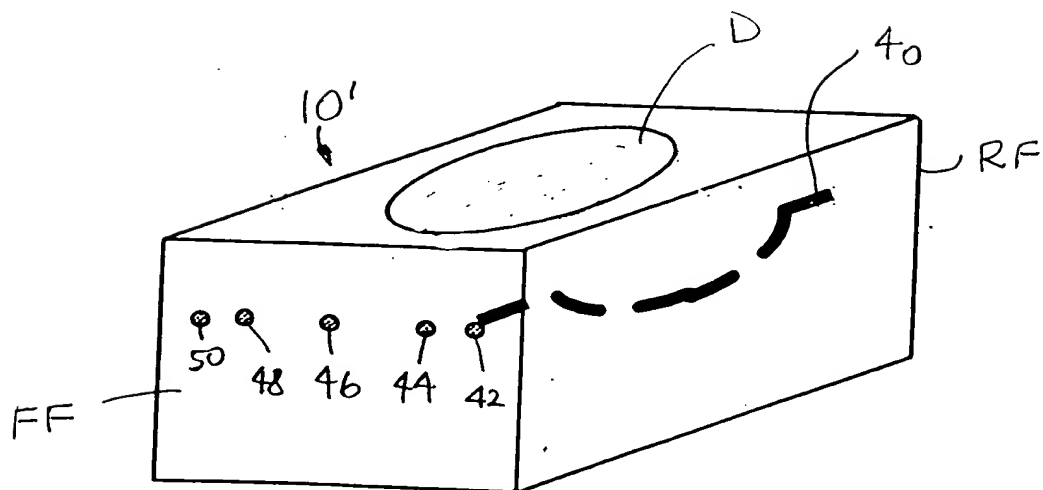


FIG. 4

FIG. 5A

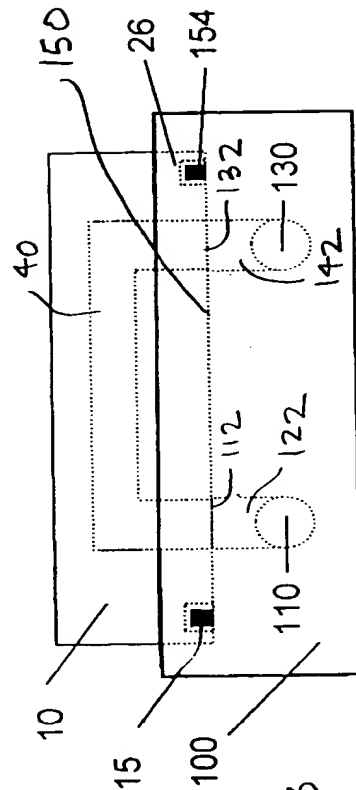
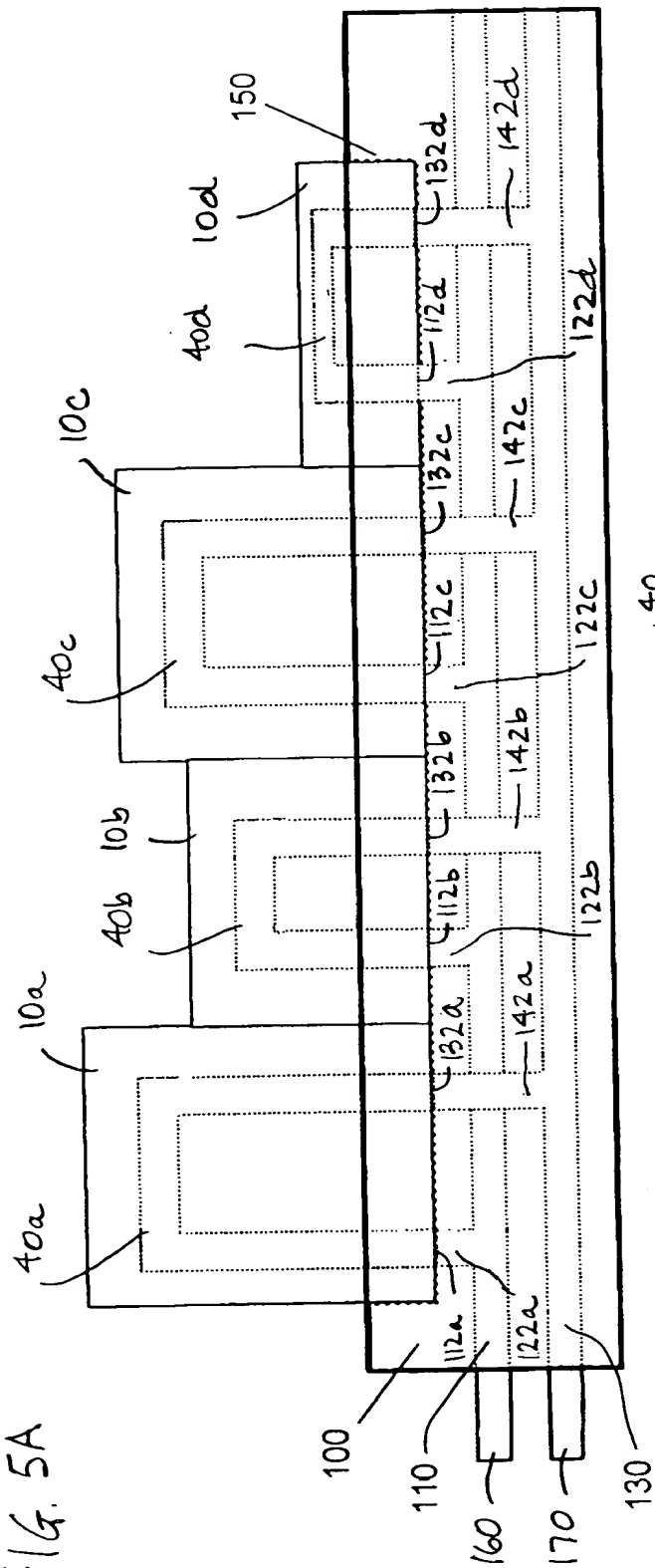


FIG. 5B

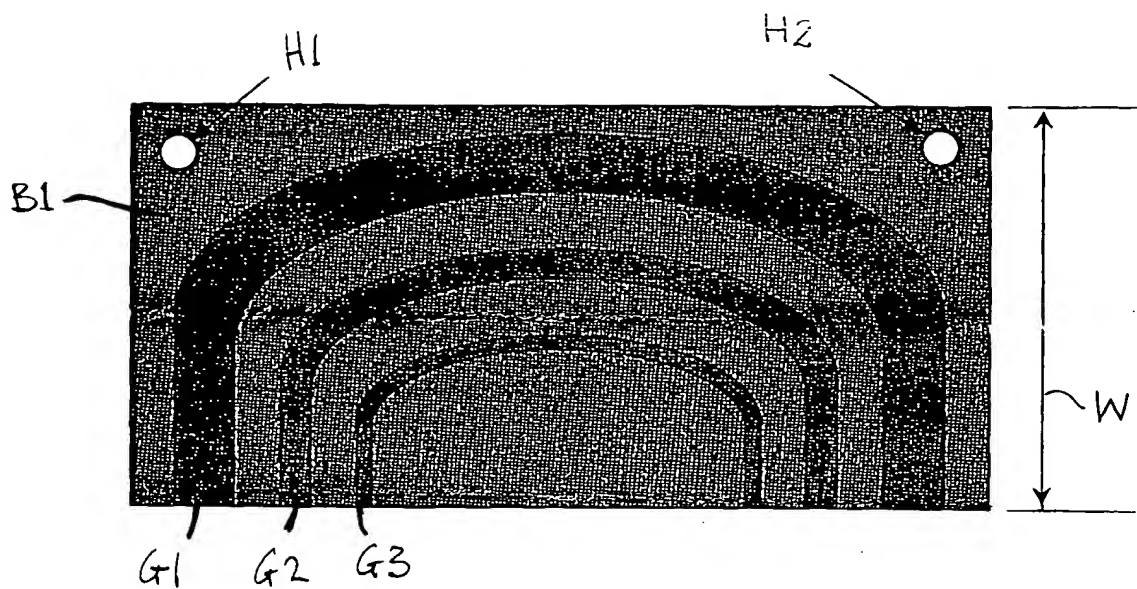


FIG. 6A

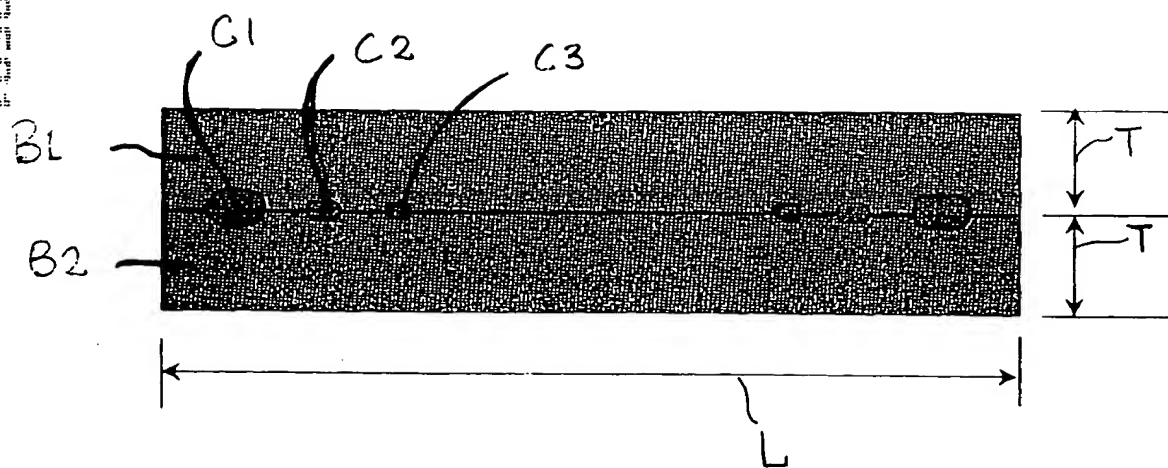


FIG. 6B

BOND STRENGTH

Bond Pressure ksi	% Deformation	Heat Treated	Hardness, Rc	Strength, ksi
0.75	0.13	N	28	53
0.75	0.13	Y	54	45
1.5	1.5	N	30	143
1.5	1.5	Y	46	189
3.0	15.1	N	28	158
3.0	15.1	Y	46	219

S7 Strength:

S7 Hardness = 50 Rc

Annealed = 93 ksi

Heat Treated = 300 ksi

FIG. 7

FIG. 8A

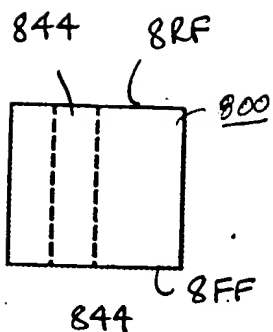


FIG. 8B

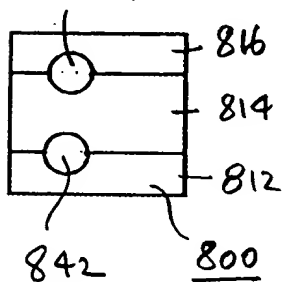


FIG. 9A

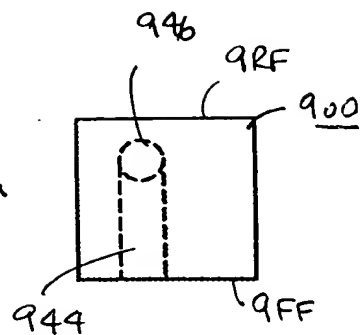


FIG. 9B

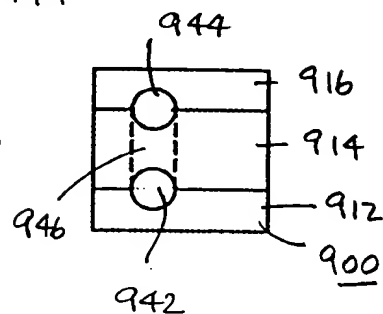


FIG. 10A

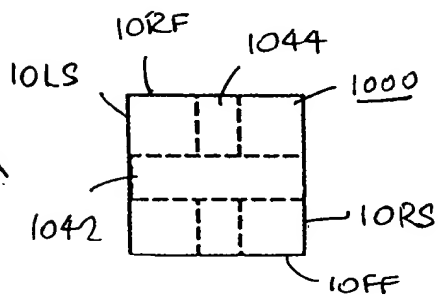


FIG. 10B

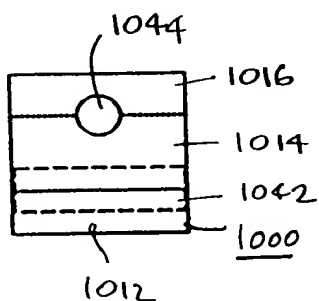


FIG. 11A

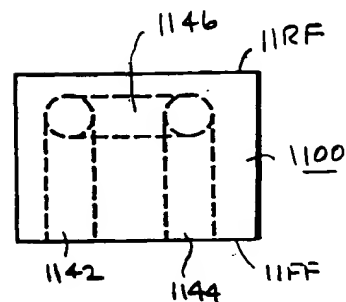


FIG. 11B

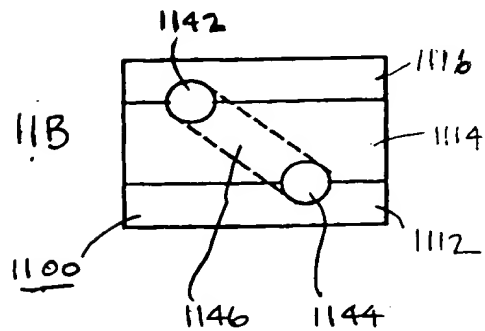


FIG. 12A

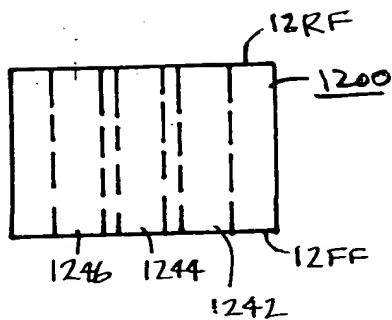


FIG. 13A

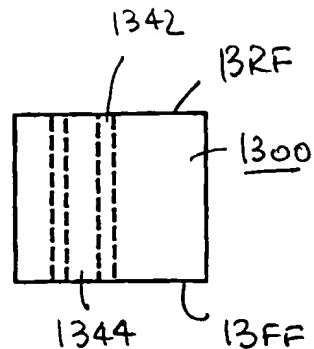


FIG. 12B

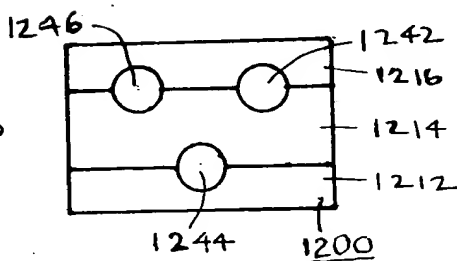


FIG. 13B

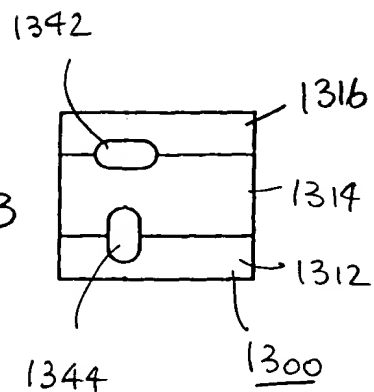


FIG. 14A

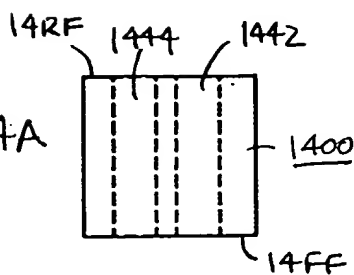


FIG. 15A

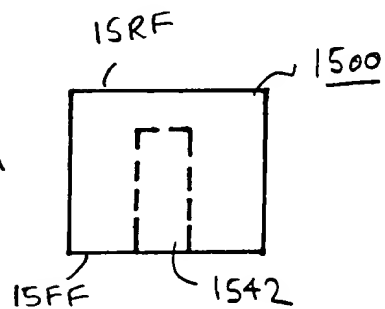


FIG. 14B

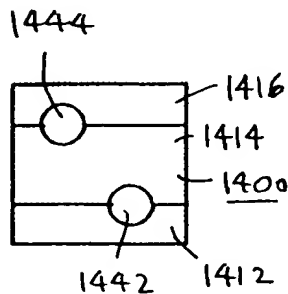


FIG. 15B

